

CLAIM AMENDMENTS

1 - 17. (canceled)

1           18. (previously presented) A method of making a fiber  
2 laminate, the method comprising the steps of sequentially:

3           a) forming a nonwoven spunbond filament layer;

4           b) prebonding the nonwoven spunbond filament layer to a  
5 tensile strength of at least 50% of the tensile strength thereof at  
6 maximum bonding as defined in DIN 53815 to form a prebonded  
7 nonwoven spunbond filament layer;

8           b') treating the prebonded nonwoven spunbond filament  
9 layer with at least one wetting agent;

10           c) applying at least one layer of hydrophilic fibers onto  
11 the prebonded nonwoven spunbond filament layer treated with the  
12 wetting agent; and

13           d) hydrodynamically bonding the layer of hydrophilic  
14 fibers to the spunbond filament layer to create a two-layer  
15 laminate forming an absorbent cloth.

1           19. (previously presented) The method defined in claim  
2 18 wherein the nonwoven spunbond filament layer is prebonded in  
3 step b) in a calender.

1           20. (previously presented) The method defined in claim  
2 19 wherein the nonwoven spunbond filament layer is prebonded in

3     step b) in a calender having at least one heated embossing drum  
4     cylinder.

1             21. (previously presented) The method defined in claim  
2     20 wherein the prebonding is carried out in step b) such that a  
3     maximum free filament length between two bonding points of the  
4     nonwoven spunbond layer is less than 15 mm.

1             22. (previously presented) The method defined in claim  
2     21, further comprising the step of additionally deforming the  
3     prebonded nonwoven spunbond filament layer to increase the  
4     thickness thereof.

1             23. (previously presented) The method defined in claim  
2     22 wherein the hydrophilic fibers are applied by at least one  
3     carding machine or at least one air-layering device onto the  
4     prebonded nonwoven spunbond filament layer.

1             24. (previously presented) The method defined in claim  
2     23, further comprising the step of applying a second spunbond  
3     nonwoven material onto the laminate formed by the layers.

1             25. (previously presented) The method defined in claim  
2     24 wherein the hydrodynamic bonding of the layers into the laminate  
3     is effected by a water-jet treatment thereof.

1           26. (previously presented) The method defined in claim  
2   18 wherein the prebonding is carried out in step b) such that a  
3   maximum free filament length between two bonding points of the  
4   nonwoven spunbond layer is less than 15 mm.

1           27. (previously presented) The method defined in claim  
2   18, further comprising the step of additionally deforming the  
3   prebonded nonwoven spunbond filament layer to increase the  
4   thickness thereof.

1           28. (previously presented) The method defined in claim  
2   18 wherein the wetting agent is at least one tenside or surface  
3   active agent.

1           29. (previously presented) The method defined in claim  
2   18 wherein the hydrophilic fibers are applied by at least one  
3   carding machine or at least one air-layering device onto the  
4   prebonded nonwoven spunbond filament layer.

1           30. (previously presented) The method defined in claim  
2   18, further comprising the step of applying a second spunbond  
3   nonwoven material onto the laminate formed by the layers.

1           31. (previously presented) The method defined in claim  
2   18 wherein the hydrodynamic bonding of the layers into the laminate  
3   is effected by a water-jet treatment thereof.

1           32. (new) A method of making a fiber laminate, the  
2 method comprising the steps of sequentially:

3           a) forming a nonwoven spunbond filament layer;

4           b) prebonding the nonwoven spunbond filament layer to a  
5 tensile strength of at least 50% of the tensile strength thereof at  
6 maximum bonding as defined in DIN 53815 to form a prebonded  
7 nonwoven spunbond filament layer such that a maximum free path  
8 length between two bonding points of the spunbond filaments is less  
9 than 15 mm;

10          c) treating the prebonded nonwoven spunbond filament  
11 layer with at least one wetting agent;

12          d) applying at least one layer of hydrophilic fibers onto  
13 the prebonded nonwoven spunbond filament layer treated with the  
14 wetting agent; and

15          e) hydrodynamically bonding the layer of hydrophilic  
16 fibers to the spunbond filament layer to create a two-layer  
17 laminate forming an absorbent cloth.

1           33. (new) A method of making a fiber laminate, the  
2 method comprising the steps of sequentially:

3           a) forming a nonwoven spunbond filament layer;

4           b) prebonding the nonwoven spunbond filament layer to a  
5 tensile strength of at least 50% of the tensile strength thereof at  
6 maximum bonding as defined in DIN 53815 to form a prebonded  
7 nonwoven spunbond filament layer;

8           c) deforming the prebonded spunbond filament layer so as  
9 to increase its thickness;

10          d) treating the prebonded nonwoven spunbond filament  
11 layer with at least one wetting agent;

12          e) applying at least one layer of hydrophilic fibers onto  
13 the prebonded nonwoven spunbond filament layer treated with the  
14 wetting agent; and

15          f) hydrodynamically bonding the layer of hydrophilic  
16 fibers to the spunbond filament layer to create a two-layer  
17 laminate forming an absorbent cloth.

1           34. (new) A method of making a fiber laminate, the  
2 method comprising the steps of sequentially:

3           a) forming a nonwoven spunbond filament layer;

4           b) prebonding the nonwoven spunbond filament layer to a  
5 tensile strength of at least 50% of the tensile strength thereof at  
6 maximum bonding as defined in DIN 53815 to form a prebonded  
7 nonwoven spunbond filament layer such that a maximum free path  
8 length between two bonding points of the spunbond filaments is less  
9 than 15 mm;

10          c) deforming the prebonded spunbond filament layer so as  
11 to increase its thickness;

12          d) treating the thickness-increased prebonded nonwoven  
13 spunbond filament layer with at least one wetting agent;

14          e) applying at least one layer of hydrophilic fibers onto  
15 the prebonded nonwoven spunbond filament layer treated with the  
16 wetting agent; and

17          f) hydrodynamically bonding the layer of hydrophilic  
18 fibers to the spunbond filament layer to create a two-layer  
19 laminate forming an absorbent cloth.